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Canada

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D3913-041
Job Sheet 182366



Part No: D3913-041

Job Qty: 1 ea

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/23/18

Job Tracking No:

Due Date: 9/7/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV.B DD VERF:EC IPP REV:D 13.08.21 DWG REV.C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	9/7/18	9/7/18	0.00	0.00	Start Up Large Fab-5		2018-08-31
100	Large Fab	1 pcs	9/7/18	9/7/18	0.00	10.00	Large Fab 1		2018-09-01
110	QC	1 pcs	9/7/18	9/7/18	0.00	0.00	QC9		
120	QC	1 pcs	9/7/18	9/7/18	0.00	0.00	QC5		
125	HandFinish	1 pcs	9/7/18	9/7/18	0.00	0.29	HandFinish2		18-09-06
130	Powdercoat	1 pcs	9/7/18	9/7/18	0.00	0.93	Powdercoat2		18-9-6
140	QC	1 pcs	9/7/18	9/7/18	0.00	0.00	QC3		18-9-6
150	HandFinish	1 pcs	9/7/18	9/7/18	0.00	0.50	HandFinish4		18-9-7
160	QC	1 pcs	9/7/18	9/7/18	0.00	0.00	QC5		18-9-7
170	Packaging	1 pcs	9/7/18	9/7/18	0.00	0.00	Packaging3-2		18-9-7
180	QC21-SA	1 Ea	9/7/18	9/7/18	0.00	0.00	QC21		18-09-07

Part Op 100 - 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect before welding mesh*** 2-Cut D4020-1 base
Descriptions: mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners
holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4-
Weld D4672-1 blanking plates as per dwg
130 - 1- Plug holes and mask only interior of hinge (3) prior to powder coat
150 - Pick Kit

M 83893

START: 2:05 OUT: 3:50 FINISH: 2:20

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	5089833
D3913-1	Rib	1 Ea (1 ea)	90-Start up Operation	5096632
D3913-15	Wide Handle Plate	1 Ea (1 ea)	90-Start up Operation	5093386
D3913-3	Rib	1 Ea (1 ea)	90-Start up Operation	5096630
D3913-7	Rib	2 Ea (2 ea)	90-Start up Operation	5096603
D3913-9	Hinge Rib	1 Ea (1 ea)	90-Start up Operation	5084677
D3916-041	Rib Assembly	2 Ea (2 ea)	90-Start up Operation	5101540
D3916-5	Light Rib	3 Ea (3 ea)	90-Start up Operation	5093147
D4016-1	Hinge Half, Base	3 Ea (3 ea)	90-Start up Operation	5094264
D4017-7	Rib	3 Ea (3 ea)	90-Start up Operation	5068796
D4017-9	Rib	2 Ea (2 ea)	90-Start up Operation	5101818
D4020-11	End Mesh, Basket	2 Ea (2 ea)	90-Start up Operation	5097017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : _____					

D4021-1	Handle Plate	3 Ea (3 ea)	90-Start up Operation
D4034-041	Aft Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation
D4034-043	Fwd Upper Rib Assembly	1 Ea (1 ea)	90-Start up Operation
D4672-1	Blanking Plate	2 Ea (2 ea)	90-Start up Operation
M304EX0.75-16F	Expanded Metal Flat SS	33 sf (33 ea)	90-Start up Operation
AN3-10A	Bolt	6 Ea (6 ea)	150-HandFinish
D2931	Bumper	2 Ea (2 ea)	150-HandFinish
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-HandFinish
MS21042L3	Nut	6 Ea (6 ea)	150-HandFinish
NAS1149F0332P	Washer	12 Ea (12 ea)	150-HandFinish
D4021-5	Blanking Plate	2 Ea (2 ea)	150-HandFinish

5089804
 5100984
 5100985
 5089950
 5093684
 5089298-1
 F86435
 FM137417-40
 5078257
 5103666
 5672828

Job Allocations

005339

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2581	2	68	0
	D3913-1	1	8	0
	D3913-15	1	13	0
	D3913-3	1	9	0
	D3913-7	2	6	0
	D3913-9	1	13	0
	D3916-041	2	4	0
	D3916-5	3	9	0
	D4016-1	3	12	0
	D4017-7	3	31	0
	D4017-9	2	10	0
	D4020-11	2	11	0
	D4021-1	3	28	0
	D4034-041	1	2	0
	D4034-043	1	1	0
	D4672-1	2	26	0
	M304EX0.75-16F	33	1,615	0
	AN3-10A	6	133	0
	D2931	2	970	0
150-HandFinish	D4021-5	2	32	0
	MS20600-AD4W3	2	231	0
	MS21042L3	6	3,868	0
	NAS1149F0332P	12	1,735	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order update only

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QSI042) Approval	
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	

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Date: 08/31/18

CART
AEROSPACE

Container No: S107373

Part: D3913 - 041

Job No: 182366

Serial No/Batch: S107373

Revision:

Inspector:
Exp Date:

Instructions: Various STC's

MULTI CATEGORY

	☐ Power Loss/Surge	☐ Positioned Wrong
	☐ Folio/Program	☐ Outside Dimensions
	☐ Grain	☐ Over/Under tolerance
:t	☐ Weld	☐ Part Incorrect
/Unqualified	☐ Wrong Stock Pulled	☐ Part Lost/Missing
	☐ Out of Sequence	☐ Part Moved
	☐ Off-set	☐ Drawing
	☐ Misabeled	☐ Finish
e/Unclear	☐ Fit/Function	☐ Misread
	☐ Misaligned/off center	☐ Turning Sequence

H:/10111113/Quang, Assurance (app) 11-20-2017